

Work Order ID 55781

February 1, 2010 10:11:27 AM

Page 1

Item ID: D206-667-203BL

Accept

Setup Start

Revision ID:

Stop

Item Name: Crosstube Aft, Blue

Start Date: 2/02/10 Start Qty: 1.00

Cust Item ID:

Required Date: 2/18/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-02-1

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D206-667-243

C

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels as per PPP D206-667-203 CHG003

0.00

0.00

110

CNC Bend 2

CNC Alpha 160 Bender

BENDING MACHINE - CROSSTUBES

Memo

Bend tube as per Dwg D206-667-243 using CNC bender program 206L-AF and Folio FT

0.00

0.00

120

QC

Quality Control

QC15- Crosstube Dimensional Check

Memo

0.00

0.00

Handwritten notes: "Salebr" and "for LL 10/02/25"

Handwritten notes: "MB 10-02-02"

Handwritten note: "=> 8/10/02/02"

Handwritten note: "YU"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Crosstubes								
Crosstubes	Memo	0.00							
Crosstubes	1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill all (3) top holes.								
	2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243 Check dimensions between holes on all four sides.								
	3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.								
	4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill only the top (2) holes.								
	5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243								
	6-Drill Fwd rivet holes using drill Jig DT8789FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.								
	7-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D206-667-243.								
	8-C'sink holes as per Dwg D206-667-243.								
	9 -Scribe part # and batch # using vibrating stylus as per Dwg D206-667-243 Inside of Cuff(Donot engrave on outside of tube)								
	10 -Deburr & Inspect for surface damage. Repair damage within limits as per Dwg								

AWM

MA

10-02-02

MB
10-02-03

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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

D206-667-243

140

Crosstubes Chemical Conversion

0.00



HandFXtube

Memo

0.00

Hand Finishing Crosstubes

1 - AWH 10-2-3

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

⇒ Sidorov

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ Sidorov

(XL)

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Outsource process - NDT per QSI038 4.1

0.00



Outsource2

Memo

0.00

Outsource process - NDT

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 11304

LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

P/O 10-2-16
①

180

Packaging

0.00



Packaging

Memo

0.00

Packaging

Ensure copy of NDT results attached to work order.

P/O 10-2-16
②

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Ensure results are as per Dwg D206-667-243

P/O 10-02-17
①

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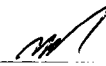

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200  SprayPaint	SprayPaint	0.00					10	02	17 (1)
Spray Painting	<p>Memo</p> <p>1-Prime inside and outside crosstube grey as per QSI 005 4.2</p> <p>2-Paint outside crosstube <i>Primer: 110918</i></p> <p>Delfleet Blue B <i>113171</i></p> <p>Clear Delfleet B <i>110896</i></p> <p>as per QSI 005 4.2</p> <p>Start Time: <u>10:00</u></p> <p>Finish Time: <u>11:00</u></p> <p>PAINT:</p> <p>Start Time: <u>3:00</u></p> <p>Finish Time: <u>4:00</u></p>	0.00							
210  QC	QC14- Inspect Spray Paint	0.00							
Quality Control	<p>Memo</p> <p>Wrap in plastic bag to protect from scratches</p>	0.00							

RT 10-02-18

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Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							
	Crosstubes					m	18	02	18
Crosstubes	Memo	0.00							
Crosstubes	1-Install nut plates as per Dwg D206-667-243.								
230		0.00							
	Skidtubes					m	10	02	18 (1)
Skidtubes	Memo	0.00							
Skidtubes	1-Install support using 0.03" to 0.06" thick layer of magnobond 6398 per QSI 015. Let cure for 12h after installation and prior to packaging. Note: (3) top holes should be facing up. A/R Magnobond 6398 : 112417 exp: 01/2011								
	2-Install supports and clamps as per Dwg D206-667-243. Torque clamps to 80-100 in lb								

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Customer:






Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	8.10.02/23						
250  Packaging Packaging	Pick Kit Memo	0.00 0.00					10-2-25		
260  QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00	5.10.02/25						

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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-667-203								
	Location: _____								
	PPP Rev: <u>D</u>								
280		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

10-2-26

10/03/03

10-2-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

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Parent Item: D206-667-203BL

Parent Item Name: Crosstube Aft, Blue

Comments:

Start Date: 2/02/10

Required Date: 2/18/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN5-10A		Purchased	No				Each	102.0000	10.0000			
---------	--	-----------	----	--	--	--	------	----------	---------	--	--	--

Bolt

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST	102	
107013	8	
110363	2	
112314	1	
113149	1	
113524	90	



10-2-25

sf

AN5-32A

Bolt

Purchased No

Each 172.0000 4.0000

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST	172	
106242	3	
106519	4	
110363	17	
112933	48	
113121	100	



16-2-25 sf

4

W/O:		WORK ORDER CHANGES					
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---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN5-34A

Purchased

No

Each

146.0000

4.0000



Bolt

10-2-25 sl

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

146

104679

2

107013

2

113149

92

113226

50

4

NAS149D03632 Q5101750

AN960JD516

Purchased

No

Each

0.0000

18.0000



Washer

D206-667-203TRN

Manufactured

No

Each

4.0000

1.0000



Crosstube Turning Detail

MU3524 sl

MB 10-02-02

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

4

53414

1

53415

1

53649

1

53651

1

MB 10-02-02

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D2873-043		Manufactured	No				Each	47.0000	2.0000			
Nut Plate Assembly												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	47	
45370	2	
45422	1	
50002	4	
<u>50871</u>	20	
53966	20	

m 10 02 18

D2873-045		Manufactured	No				Each	65.0000	2.0000			
Nut Plate Assembly												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	65	
45210	3	
<u>50001</u>	22	
53967	20	
53968	20	

m 10 02 18

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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D2892-1		Manufactured	No				Each	51.0000	2.0000			
												
Support												

Blue

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	51	
41986	12	
42785	20	
53124	13	
<u>53348</u>	6	

m/ 10/02/18

D3595-063-450	Manufactured	No
		
RUBBER CUSHION		

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	51.15767369	
<u>52447</u>	51.1576737	
Main Warehouse		
ST	104.9689	
38959	2	
43210	2.59	
46465	0.3789	
<u>53775</u>	100	

m/ 10 02 18

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MS20601-AD4W10		Purchased	No				Each	159.0000	14.0000			
RIVET												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	159	
110665	16	
111177	43	
113220	100	

ml 10 02 18

MS21042L5

Purchased

No



Nut

Each

533.0000

4.0000



10-2-25 SD

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	533	
110382	10	
111636	1	
112314	22	
113523	300	
113537	200	

4

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Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21920-22		Purchased	No				Each	62.0000	4.0000			
Clamp(per MIL-DTL-8783C)												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	62	
109495	6	
<u>110260</u>	6	
111210	50	

ml 10 02 18

February 1, 2010 10:11:32 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

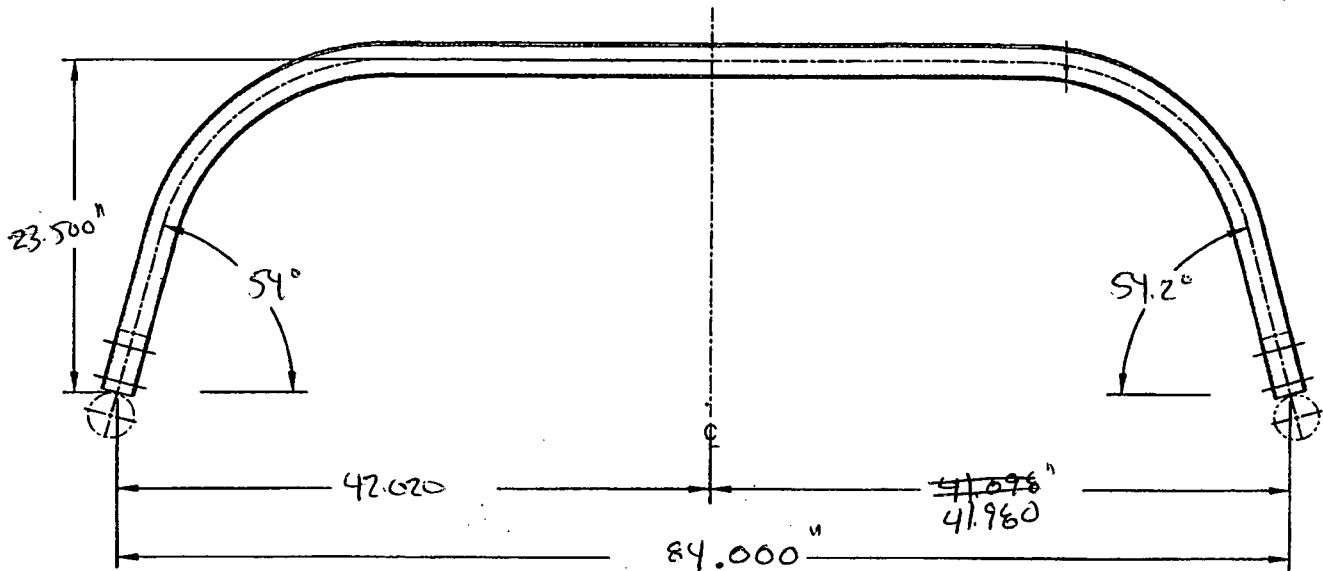
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	55781
Description: Crosstube High Aft (206L)		Part Number:	D206-667-203
Inspection Dwg: D206-667-243 Rev: C		Page 1 of 1	

Required Dimension	Min	Max
Height	23.39	23.65
1/2 Span	41.79	42.05
Angle	54	56
Total Span	83.58	84.1



Comments

QC15 Inspection	S
Date	10/02/02

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	09.11.17	Dwg Rev updated	KJ	
C	09.12.14	Dimensions update per Dwg Rev C	KJ	

Item	Qty -243	Part Number	Description
1	X	D206-667-243	CROSSTUBE ASSEMBLY (206L HIGH AFT)
2	1	D6004-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2892-1	SUPPORT
6	4	D3595-063-450	RUBBER CUSHION
7	4	MS21920-22	CLAMP
8	14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

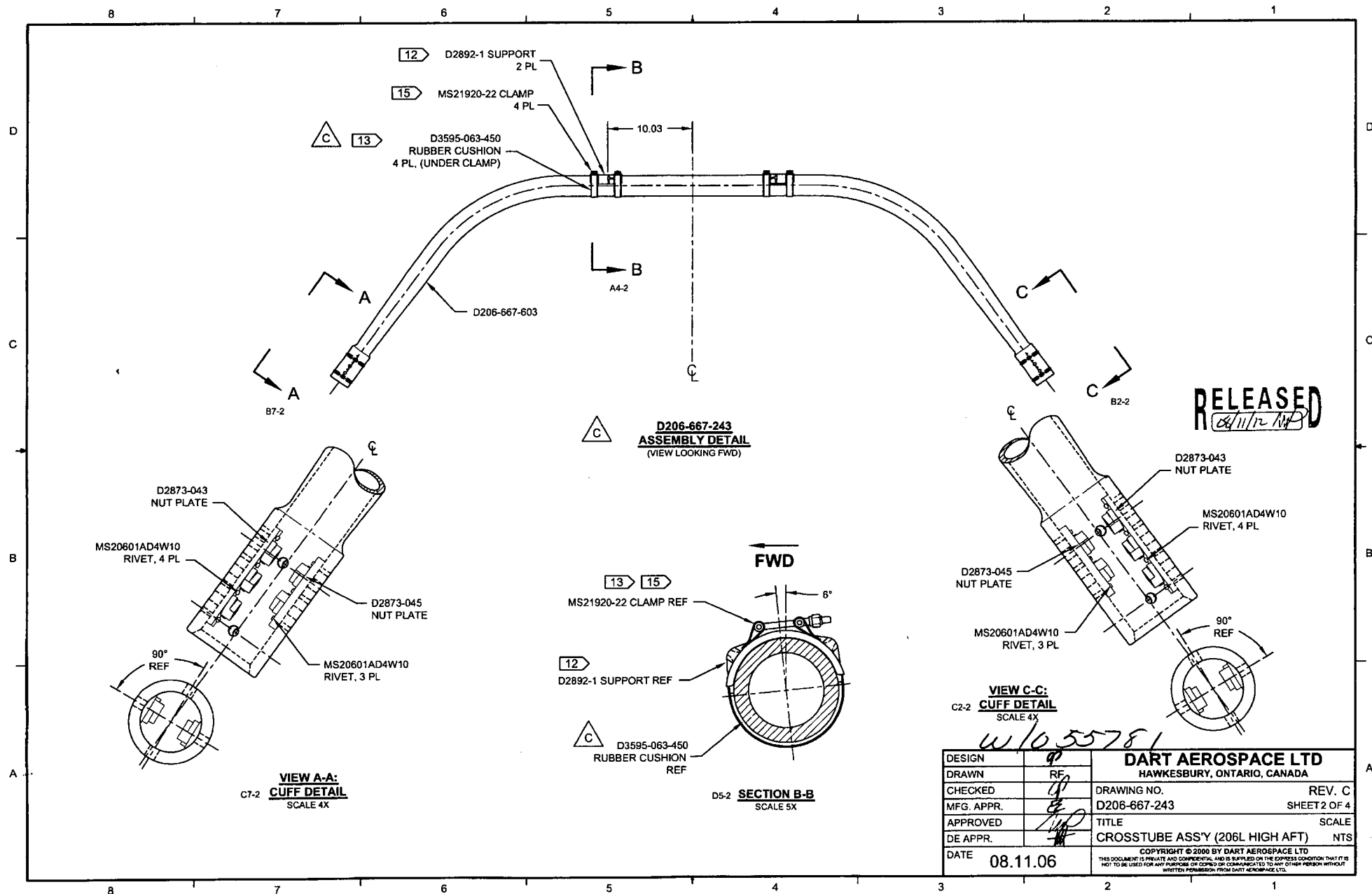
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55781
BD 10-02-01

GENERAL NOTES:

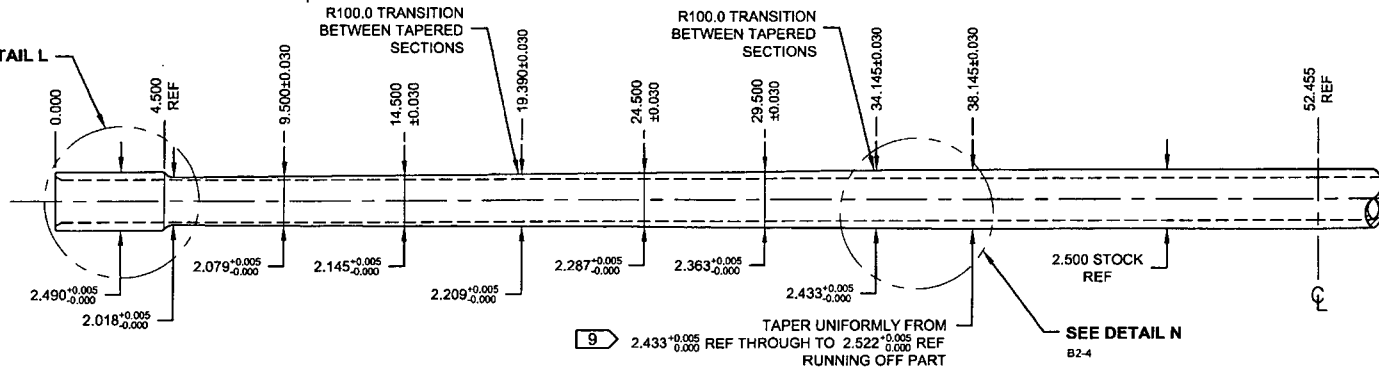
- 1) MATERIAL: MANUFACTURED FROM D6004-115
FINISHED LENGTH = 104.91±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-243" AND BATCH NUMBER ON
INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 21.9 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY,
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER
QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-22 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE
D2892-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE
LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN.-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
08/11/06

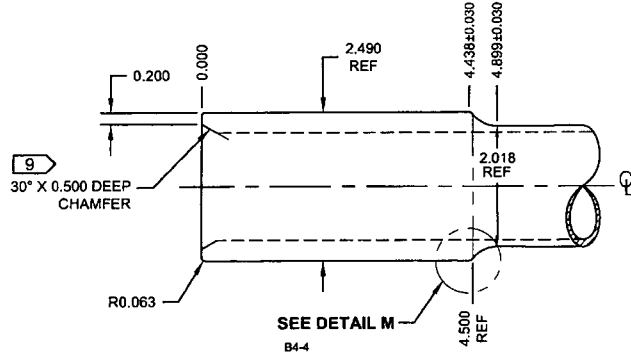
C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-450 WAS D2856-400-773 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN 4-3, C5-3, D3-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>qp</u>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<u>RF</u>	DRAWING NO.	REV. C
CHECKED	<u>lp</u>	D206-667-243	SHEET 1 OF 4
MFG. APPR.	<u>lp</u>	TITLE	SCALE
APPROVED	<u>lp</u>	CROSSTUBE ASS'Y (206L HIGH AFT)	NTS
DE APPR.	<u>lp</u>	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.11.06		



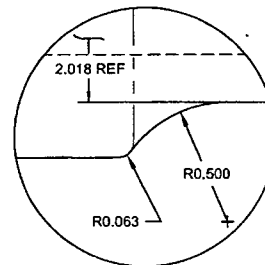
SEE DETAIL L
B7-4



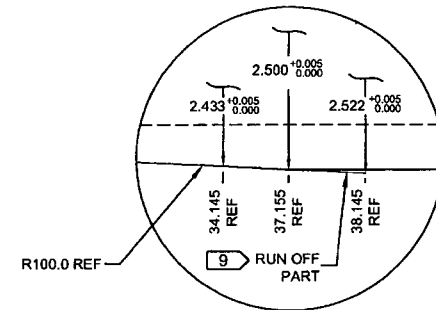
TURNING DETAIL



DETAIL L: CROSSTUBE CUFF
NOT TO SCALE



DETAIL M: CUFF TRANSITION
NOT TO SCALE



DETAIL N: TAPER RUN-OFF
NOT TO SCALE

RELEASED
08/11/12

DESIGN	W1053781	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. C
CHECKED	GP	D206-667-243	SHEET 4 OF 4
MFG. APPR.	GP	TITLE	SCALE
APPROVED	GP	CROSSTUBE ASS'Y (206L HIGH AFT)	NTS
DE APPR.	GP	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.11.06		



LIQUID PENETRANT TEST REPORT

P- 15318

PAGE 1 OF 1

IN

EXAMINED

DAT AERU SPACE

LINDA / CHATEL

127 ABIDEAN ST.

MARKESBURY IN, KGH JKT

F.P.E. ON

E P.S

DATE

FEB 11-2010

TIME AM ☒ PM ☐

ACUREN JOB No.

100-10-0051

POWOW No.

11364

WORK LOCATION

5400

ACCEPTANCE STD.

ASTM 1417

REV./DATE 2007

DESCRIPTION

PROCEDURE No. LT-002 REV./DATE

TECHNIQUE No. LT-TECH 2 REV./DATE

MATERIAL ALUMINUM THICKNESS

WET FLUORESCENT LIQUID PENETRANT INSPECTION
CARRIED OUT 100% EXTERNAL

DETAILS

☒ FLUORESCENT

☐ VISIBLE

☒ WATER WASH

☐ SOLVENT REMOVABLE

☐ POST EMULSIFIED

BRAND

ALASAFLEX

BLACK LIGHT S/N 10459

☒ OUTPUT > 1000 μ W/cm²

☐ AMBIENT < 2 fc

INT

2407

MINIMUM DWELL TIME 45 MIN.

MIN.

LIGHTING EQUIP.

☐ FLASHLIGHT

☐ TROUBLELIGHT

☐ OUTPUT > 100 fc @ SURFACE

INT REMOVER

M20

MINIMUM DRY TIME > 10 MIN.

MIN.

OTHER LABING

PER

SKD 52

MINIMUM DWELL TIME 10 MIN.

MIN.

LIGHT METER S/N

1098866

CAL DUE DATE

MAY 7-2010

PER TYPE

☒ NON AQUEOUS

☐ AQUEOUS

☐ DRY

SURFACE

CONDITION

☐ AS GROUND

☐ AS WELDED

☒ MACHINED

☐ SHOT BLASTED

☐ CLEAN BARE METAL

TEMPERATURE

☐ < -4°C/20°F

☐ -4°C/20°F TO 10°C/50°F

☒ 10°C/50°F TO 52°C/125°F

☐ > 52°C/125°F

TS-

☐ METRIC ☐ IMPERIAL

CROSSTUBE W.C. 55759 ✓
CROSSTUBE W.C. 55760 ✓
CROSSTUBE W.C. 55779 ✓
CROSSTUBE W.C. 55780 ✓

CROSSTUBE W.C. 55781 ✓
CROSSTUBE W.C. 55782 ✓
CROSSTUBE W.C. 55134 ✓
CROSSTUBE W.C. 55135 ✓

ALL ITEMS EXAMINED ON
THIS REPORT HAVE BEEN
ACCEPTED TO STANDARD.

10 02 17

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Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that no representations, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

of Care

In the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

TURES

REPRESENTATIVE

Jan Tilly

PRINT

SIGNATURE

DTR# E27362

CIAN (SIGNATURE):

Mike Foster

REPORT

REVIEWED BY:

(PRINT):

Mike Foster

NAME

INITIALS

1st TECHNICIAN

2nd TECHNICIAN

CGSB LEVEL

E

SNT LEVEL

II

CGSB LEVEL

SNT LEVEL

CGSB REG. NO

6606

CGSB REG. NO

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PT Sept 2005